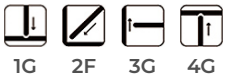
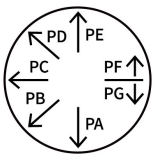
SM-1N

Classification

AWS A5.28/ ASME SFA-5.28 ER80S-Ni1

Welding Positions





Features

- Impact value in low temp. is good
- Excellent bead appearance & weldability

Polarity

DC +

Application Areas

- Oil & gas industry
- Offshore industry
- Power plant, chemical industry

Shielding Gas

Ar + 20% CO2

Approvals

ABS
✓

Typical Chemical Composition of the Wire (wt%)

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V
0.11	0.66	1.11	0.019	0.001	0.14	0.95	0.05	0.01	0.01

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
Ar + 20% CO2	500 (73)	590 (86)	28	-45 (-50) -60 (-75)	115 (85) 40 (30)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Packaging
1.0 (0.039), 1.2 (0.045), 1.4 (0.052), 1.6 (1/16)	Spool 15kg(33lbs)